Work Order ID 77748

77748

December-21-11 7:51:00 AM

Item ID: D412-664-203

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Crosstube Aft

Start Date: 12/21/11 **Start Qty:** 1.00 *1*

Required Date: 12/28/11 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D412-664-243	E/DEO

100
100
DC
Document Control

DOCUMENT CONTROL — 0.00 / 0.00

Memo
Photocopy bluefile and create labels as per PPP D412-664-203 CHG 008

W 12.01.06 (1)

110
110
Packaging
Packaging

Packaging — 0.00 / 0.00

Memo

MO 11-12-22

PTO →

120
120
CNC Bend 2
CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES — 0.00 / 0.00

Memo
Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010

JW/MO 11-12-22

Dart Aerospace Ltd

W/O: 77748		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DH12-664-203 **PAR #:** ______ **Fault Category:** X-tube **NCR:** (Yes) No **DQA:** ______ **Date:** ______

Resolution: use-as-is **Disposition:** use-as-is **QA: N/C Closed:** ______ **Date:** ______

NCR: 11-1101		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11.12.22	120	CRUSHING AFTER BENDING IS OVER TOL.	[signature] 11.12.12 05/04/12	Acceptable based on attached stress report	n/a	[signature] 12/a/09	[signature] 11.12.22 05/04/12	[signature] 12/a/09

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 77748

December-21-11 7:51:00 AM

77748

Item ID:	D412-664-203	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Crosstube Aft	**Stop**	*NS2*
Start Date:	12/21/11	**Start Qty:** 1.00	*1*
Required Date:	12/28/11	**Req'd Qty:** 1.00	*1*
Reference:			

Cust Item ID:

Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC15- Crosstube Dimensional Check **Memo**	0.00 0.00	S 11/12/22						
140 *140* Crosstubes Crosstubes	Crosstubes **Memo**	0.00 0.00							

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

POSITIVE RECALL cP
EFFECTIVE 11.12.22 AUTH [illegible]
RELEASED [illegible] DATE 11.12.22

ET 11-12-22

JW 11-12-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 77748 *77748*

December-21-11 7:51:00 AM

Item ID: D412-664-203 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Crosstube Aft **Stop** *NS2*

Start Date: 12/21/11 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 12/28/11 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo	0.00 0.00	MO		11-12-28				
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00 S 11/12/28							
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 S 11/12/28							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 77748

December-21-11 7:51:00 AM

77748

Item ID:	D412-664-203	**Accept**	*N900040100*	**Setup Start**	*NS1*
Revision ID:				**Stop**	*NS2*
Item Name:	Crosstube Aft				
Start Date:	12/21/11	**Start Qty:** 1.00	*1*	**Cust Item ID:**	
Required Date:	12/28/11	**Req'd Qty:** 1.00	*1*	**Customer:**	
Reference:					

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Outsource2	Outsource process - NDT per QSI038 4.1	0.00							11-12-29
Outsource process - NDT	**Memo** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: 15757 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00							
190 *190* Packaging	Packaging	0.00							11.12.29
Packaging	**Memo** Inspect for transit damage Ensure copy of NDT results attached to work order.	0.00							PTO →
200 *200* QC	QC5- Inspect part completeness to step on W/O	0.00							11 12 29 (1)
Quality Control	**Memo** Inspect for damage & ensure results are as per Dwg D412-664-203	0.00							

Dart Aerospace Ltd

W/O: 77748		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-203 **PAR #:** ______ **Fault Category:** X-tube Landing Gear **NCR:** Yes ~~No~~ **DQA:** [signature] **Date:** 12/1/11

Resolution: Rework **Disposition:** Re work **QA: N/C Closed:** [signature] **Date:** 12/1/11

NCR: 11-1102		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/29	# 190	Markings Found At NDT inspection R.C. Process	[signature] 092842	→ ~~Re grind~~ Blend out marks → Re Alodine As Per DS2005 → Re NDT	JW 11/12/29 n/a	[signature] 11/12/29	[signature] 092842	[signature] 11/12/29

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 77748
December-21-11 7:51:00 AM

77748

Item ID: D412-664-203 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Crosstube Aft **Stop** *NS2*

Start Date: 12/21/11 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 12/28/11 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* SprayPaint Spray Painting	SprayPaint	0.00							
	Memo ***Mask underside of crosstube as shown*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per DEO D412-664-243 and QSI 005 4.2 PRIME: Start Time: 3:30 Fininsh Time: 5:30 [initials] /AS 11-12-29 PAINT: Start Time: 7:45 Finish Time: 9:45 [initials] /AS 11-12-30	0.00							
220 *220* QC Quality Control	QC14- Inspect Spray Paint	0.00				1			[stamp] 12 01 04
	Memo Then,Wrap in plastic bag to protect from scratches	0.00							

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Item ID: D412-664-203 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Crosstube Aft **Stop** *NS2*

Start Date: 12/21/11 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 12/28/11 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* Crosstubes	Crosstubes	0.00							
Crosstubes	Memo	0.00							
240 *240* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00 S 12/01/05							

Sequence 230 memo:

Assemble as per Dwg D412-664-203

1- Install chafing shield as per DEO D412-664-243.Top holes should be facing up.
A/R Proseal 890 Batch: 119396
EXP: 05/12

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Install support with Scotch-Weld DP460 and install clamps as per DEO Dwg D12-664-243 using installaition jig DT9024. Torque clamps as per dwg
A/R Scotch-Weld DP460 Batch: 119341
EXP: 21 Oct 2012

[signature] /NR 12-01-04

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 77748 *77748*

December-21-11 7:51:00 AM

Item ID: D412-664-203 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Crosstube Aft

Start Date: 12/21/11 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 12/28/11 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250 Packaging	**Memo**	0.00				12/21/6		1	
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260 QC	**Memo**	0.00				WL	12	01	06 (1)
Quality Control									
270		0.00							
270	Packaging								
Packaging	**Memo**	0.00				12/21/6		1	
Packaging	Identify and pack for shipping as per PPP D412-664-203 ******Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date ******* Time & date of packaging: ________ Location: ________								

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 77748 *77748*

December-21-11 7:51:00 AM

Item ID: D412-664-203 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Crosstube Aft **Stop** *NS2*

Start Date: 12/21/11 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 12/28/11 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run **Start** *NR1*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280*	QC21- Final Inspection - Work Order Release	0.00					12/1/9		
QC Quality Control	**Memo**	0.00							

MF 12-01-06

Picklist Print

December-21-11 7:50:59 AM

Work Order ID: 77748

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 12/21/11 **Required Date:** 12/28/11

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
IPP Rev:G 06.12.08 per ECN 886 EC
IPP Rev:H 07-04-30 As per Rev D JLM
IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-40A Bolt		Purchased	No			250	Each	44.0000	4	4			
				Location		**Loc Qty**	**Loc Code**						
				ST342		44							
					119749	44							
AN6-41A Bolt		Purchased	No			250	Each	29.0000	2	2			
				Location		**Loc Qty**	**Loc Code**						
				ST342		29							
					119449	9							
					119749	20							
AN960JD616 Washer	NAS1149D0663J	Purchased	No			250	Each	0.0000	18	18			
D2896-1 Support		Manufactured	No			230	Each	28.0000	1	1			
				Location		**Loc Qty**	**Loc Code**						
				LG053		28							
					71502	7							
					74465	21							

119749

119449

119075

1 12-01-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID: 77748

Parent Item: D412-664-203 **Start Date:** 12/21/11 **Required Date:** 12/28/11

Parent Item Name: Crosstube Aft **Start Qty:** 1.00 **Required Qty:** 1.00

Item	Type		Qty	Unit	Amount		
D3189-1 Chafing Shield	Manufactured	No	230	Each	32.0000	2	2

Location		Loc Qty	Loc Code	
FG		4		
	36065	4		
LG053		28		
	71353	22		
	73534	6		2

Item	Type		Qty	Unit	Amount		
D3595-063-570 RUBBER CUSHION	Manufactured	No	230	Each	128.0000	2	2

Location		Loc Qty	Loc Code	
FG		8		
	37971	1		
	42243	7		
MAT052		120		
	71534	43		2
	76546	77		

Item	Type		Qty	Unit	Amount		
D412-664-203TRN Crosstube Turning Detail	Manufactured	No	110	Each	1.0000	1	1

Location		Loc Qty	Loc Code	
LG		1		
	77306	1		1

Item	Type		Qty	Unit	Amount		
MS21042L6 Nut	Purchased	No	250	Each	1,248.0000	6	6

Location		Loc Qty	Loc Code	
ST300		1248		
	117677	25		
	118384	5		
	118927	48		118968
	118968	120		
	119075	1000		
	119736	50		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID:	**77748**			
Parent Item:	**D412-664-203**	**Start Date:** 12/21/11	**Required Date:** 12/28/11
Parent Item Name:	Crosstube Aft	**Start Qty:** 1.00	**Required Qty:** 1.00

MS21920-28 Purchased No 230 Each 54.0000 **4** **4**
Clamp(per MIL-DTL-8783C)

Location		Loc Qty	Loc Code	
FG		5		
	105884	5		
LG050		49		
	116839	2		
	118713	4		
	119285	1		
	119920	42		4

AR 12-01-04

MS21920-30 Purchased No 230 Each 92.0000 **2** **2**
clamp(per MIL-DTL-8783C)

Location		Loc Qty	Loc Code	
LG		50		
	119529	50		
LG050		28		
	117998	28		2
LG051		14		
	111258	14		

AR 12-01-04

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** _____________________ **QA: N/C Closed:** __________ **Date:** _________

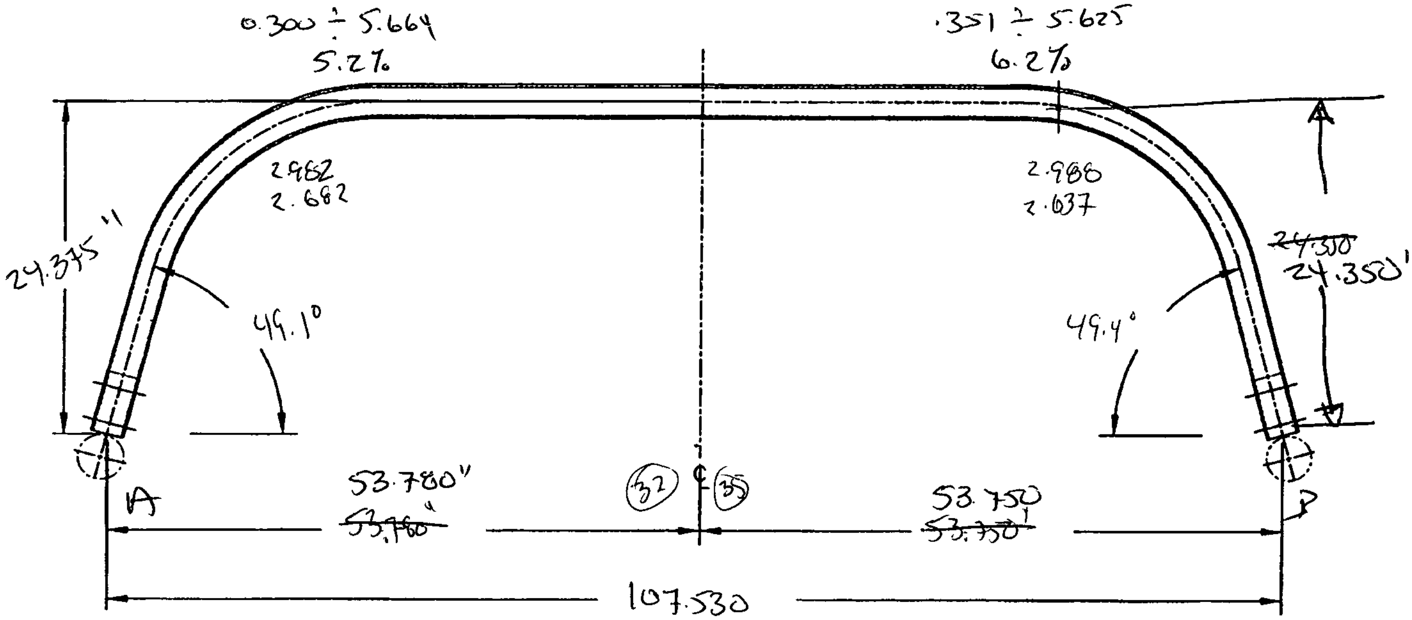
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	77710
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Side A = 5.2% crushing @ 32 passes
Side B = 6.2% crushing @ 35 passes
11.12.22

QC15 Inspection	S
Date	11/12/22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	

Item	Qty -243	Part Number	Description
1	X	**D412-664-243**	**CROSSTUBE ASSEMBLY (412 HIGH AFT)**
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6009-129
   FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
   PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

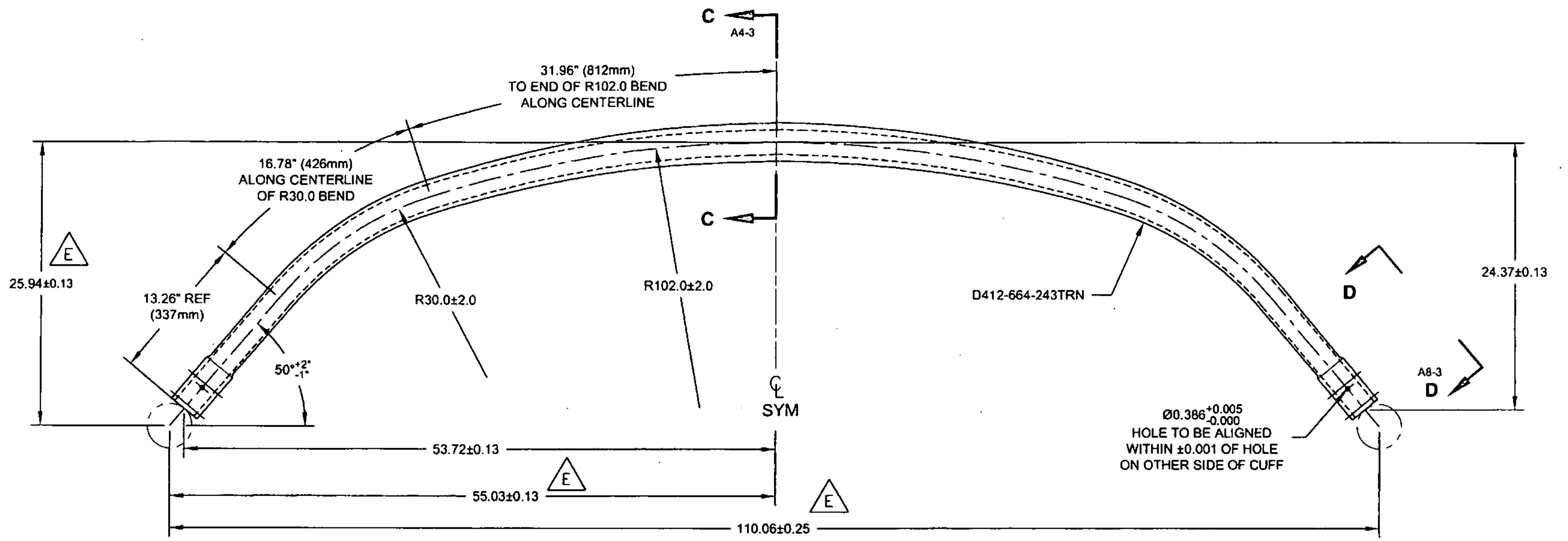
W077748

② DEO ATTACHED

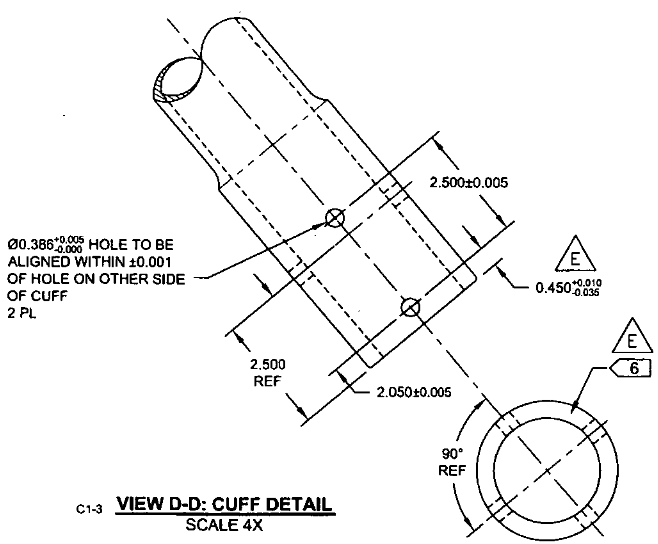
RELEASED 2009-10-29

REV.	DESCRIPTION	BY	DATE
E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17

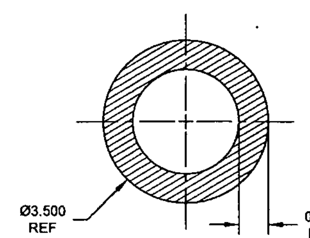
DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D412-664-243 REV. E SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) SCALE NTS
DE APPR.		
DATE	09.09.30	



D412-664-603 10
BENDING AND DRILLING DETAIL E



C1-3 **VIEW D-D: CUFF DETAIL**
SCALE 4X

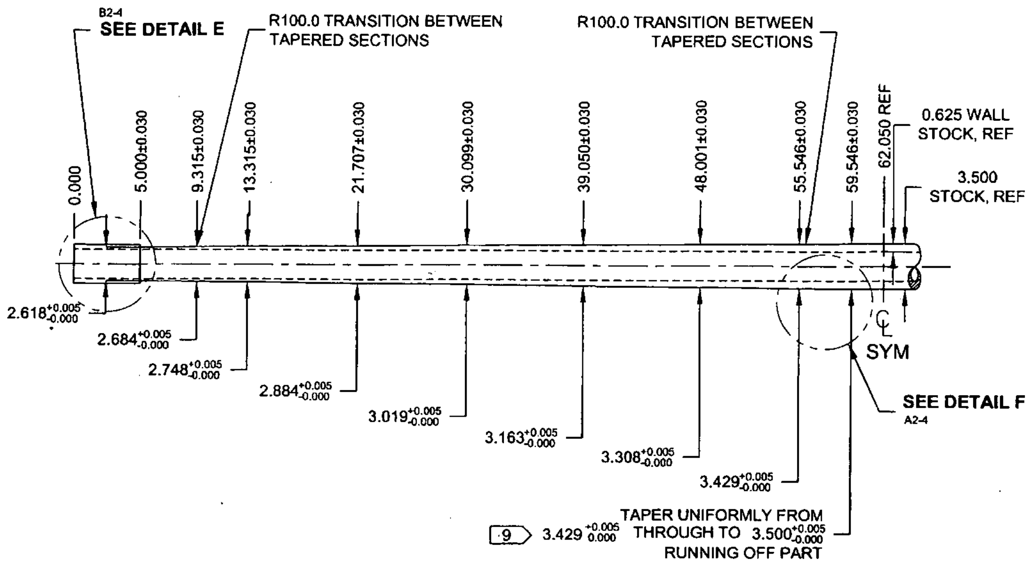


SECTION C-C D5-3
SCALE 4X

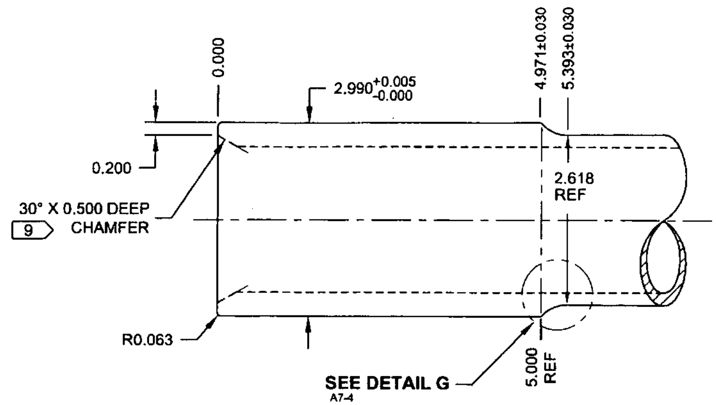
② DEO ATTACHED

RELEASED
2009 -10- 29

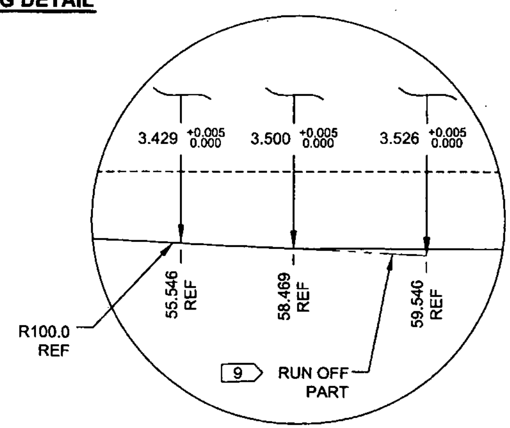
DESIGN	AH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D412-664-243	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD	



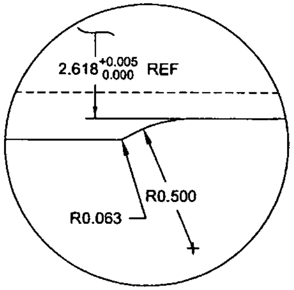
D412-664-243TRN
TURNING DETAIL E



DETAIL E:
CROSSTUBE CUFF D8-4
SCALE 5X



DETAIL F:
TAPER RUN-OFF C4-4
NOT TO SCALE



DETAIL G:
CUFF TRANSITION C2-4
SCALE 10X

2 DEO ATTACHED

RELEASED
2009 -10- 29

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D412-664-243 — REV. E — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) — SCALE NTS
DE APPR.		
DATE	09.09.30	

DRAWING NO.	TITLE	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT) REV. E		D412-664-243-E-1	SHEET 1 OF 2	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.03.31	DATE 11/03.31	DATE 11.03.31	DATE 11/03.31	DATE 11.03.31

PURPOSE:
REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

WAS:

Item	Qty -243	Part Number	Description
6	2	D2856-600-1009	ABRASION STRIP

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA

14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

RELEASED 2011-04-07

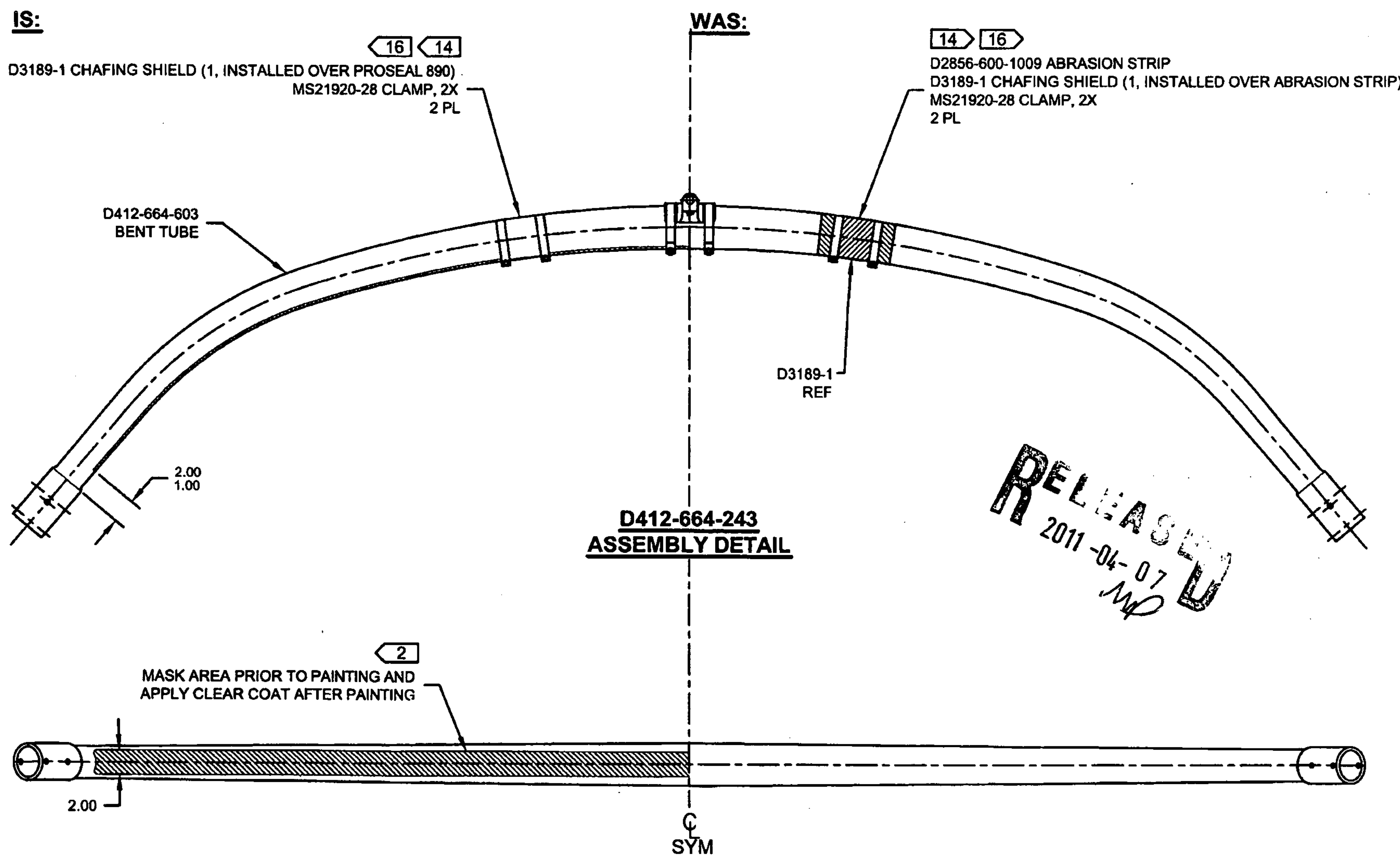
WAS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.

DRAWING NO.	TITLE	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)			D412-664-243-E-1	SHEET 2 OF 2	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.03.31	DATE 11.03.31	DATE 11-03-31	DATE 11.03.31	DATE 11.03.31



DRAWING NO.	TITLE REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASS'Y (412 HI AFT)		D412-664-243-E-2	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19

PURPOSE:
REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

Item	Qty -243	Part Number	Description
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.**

WAS:

12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

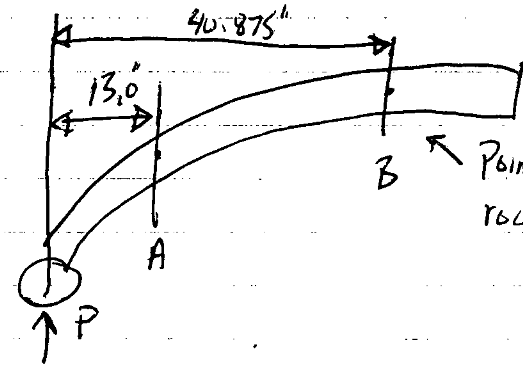
16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED 2011-09-29

11.12.06

CRUSHING OF D412-664-243

Acceptability of 8% CRUSHING AT END OF BEND



POINT A: $OD_1 = 2.961"$, $OD_2 = 2.522"$

CRUSHING $= (2.961 - 2.522)/(2.961 + 2.522) = 8\%$

$I = 1.676\ in^4$ (from AutoCAD)

Point B: $OD_1 = 3.307"$, $I = 4.613\ in^4$

A: $F = Mc/I = P \times 13 \times 2.961 / 2 \times 1.676 = 11.484 \cdot P$

B: " $= P \times 40.875 \times 3.307 / 2 \times 4.613 = 14.651 \cdot P$

$M.S. = 14.651/11.484 - 1 = 0.27$

∴ Tube will break at rocker beam contact before area of 8% crushing; 8% crushing in area at end of tube bend is acceptable

[signature] 11.12.06

Daily Time Report

E- 44217

Form dated Sep 2005

ACUREN

Client: DART AEROSPACE

Contact: CHANTAL

Location: 1270 ABERDEEN HAWKESBURY

Description: [illegible]

Report #'s: AS FOLLOWS

Job #: –

Day: Sun Mon Tues Wed **Thurs** Fri Sat

Date: DEC 29 - 2011

P.O. #: –

W.O #: [illegible]

Vehicle #: 670

Camera #: –

Name	Specialist	Tech.	CEDO	Assistant	Start Time	AM/PM	Total Hours Travel	Total Hours Worked	ST	OT	DT	SP	KM	LOA	OTM	TLD NO.	C/C	S/E	S/C	B/S	C/L	C/S	Daily DRD Readings
						AM PM																	
M. JOHNSTON		✓			6:00	AM PM	2	7					200			–							
						AM PM																	
						AM PM																	
						AM PM																	
						AM PM																	
						AM PM																	
						AM PM																	

RADIATION SAFETY CHECKLIST — SAFETY CHECKS

RADIOGRAPHIC UNIT PRICING

Weld Diameter											Long Seam					Circ. Seam				
Schedule / Thickness											Thickness					Thickness				
Quantity											Lineal Ft.					Lineal Ft.				

Film: ______ Pcs. 2 ¾ x 17"
______ Pcs. 3 ½ x 17"
______ Pcs. 4 ½ x 17"
______ Pcs. 14" x 17"
______ Pcs. ______

Consumables: ______

Equipment: ______

Client Representative: X [signature]

Place a check mark in each safety check area as completed	
C/C	CAMERA CHECK
S/E	SAFETY EQUIPMENT CHECK
S/C	SURVEY METER CHECK
B/S	BARRRIER & SIGN INSTALLED
C/L	CAMERA LOCKED & SECURELY STORED
C/S	CAMERA SURVEYED AFTER EACH USE

EXPENSES

NOTES 5 CROSSTUBES
W.O.#'S 77536, 77535, 77748
77128, 77103
MACHINED PARTS - W.O.# 77128
77103

ACUREN 1-877-299-2857

Oakville	(905) 825-8595 • Fax (905) 825-8598	Cambridge	(519) 622-3112 • Fax (519) 622-1326
Sarnia	(519) 336-3021 • Fax: (519) 336-8220	Cornwall	(613) 931-1261 • Fax (613) 931-2777
Sudbury	(705) 522-1849 • Fax (705) 522-9926	Saint John	(506) 847-0194 • Fax (506) 847-0194
Halifax	(902) 497-3870 • Fax (902) 445-5090	Thunder Bay	(807) 475-4240 • Fax (807) 577-2017
North Bay	(705) 840-8107 • Fax (705) 476-6683	Gaspé	(418) 392-3618 • Fax (418) 392-4114
Val D'Or	(819) 856-6789 • Fax (819) 825-9564	Hull	(819) 360-0685 • Fax (819) 827-3513

P- 12248

ACUREN

LIQUID PENETRANT TEST REPORT

PAGE 1 OF 1

CLIENT	Dart Aerospace	DATE	Dec 29-2011 TIME AM ☑ PM ☐
ATTENTION	Chantal	ACUREN JOB NO.	188511-1
ADDRESS	1270 Aberdeen	PO/WO NO.	515757
	Hawkesbury, ON	WORK LOCATION	Same
		ACCEPTANCE STD	ASTM 1417/031-038 REV./DATE 2005
PROJECT	FPI on Four Cross Tubes		
ITEM(S) EXAMINED	3 Engine Mounts		

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE 2008 TECHNIQUE NO. LT-Tech 2 REV./DATE 2008

PART NO. See Results MATERIAL Aludine Aluminum Stainless THICKNESS Various

SCOPE A wet fluorescent liquid penetrant inspection carried out on 100% external surface

TEST DETAILS

METHOD	☑ FLUORESCENT ☐ VISIBLE	☑ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED	
FAMILY BRAND	Magna Flux	BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 µW/cm² ☐ AMBIENT < 2 fc	
PENETRANT	ZL-67 MINIMUM DWELL TIME 15 10 MIN.	LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT>100 fc @ SURFACE	
PENETRANT REMOVER	H20 MINIMUM DRY TIME >10 MIN.	OTHER Labino	
DEVELOPER	SKD-S2 MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N 1098866	CAL DUE DATE Feb 02 2012
DEVELOPER TYPE	☑ NON AQUEOUS ☐ AQUEOUS ☐ DRY		

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☑ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL

SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☑ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1 Crosstube W.O. 77536 ✓
1 Crosstube W.O. 77535 ✓
1 Crosstube W.O. 77748 ✓ → Were reground x (2)

1 Engine Mount W.O. 77128 ✓
2 Engine Mount W.O. 77103 ✓

1 Cross Tube W.O. 78023 ✓
1 Cross Tube W.O. 78024 ✓

[signature] 11-12-29

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Andrew Sheldon (PRINT) [signature] (SIGNATURE) DTR # E44217

TECHNICIAN (SIGNATURE): [signature]

NAME (PRINT): Mike Johnston (1ST TECHNICIAN) — (2ND TECHNICIAN)

REPORT REVIEWED BY: NAME INITIALS

CGSB LEVEL II SNT LEVEL II — CGSB LEVEL ___ SNT LEVEL ___

CGSB REG. NO 6606 — CGSB REG. NO ___

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	-101	-201	-203	Part Number	Description
	X			**D212-664-101**	**CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD**
		X		**D212-664-201**	**CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT**
			X	**D412-664-203**	**CROSSTUBE INSTALLATION, 412 HIGH AFT**
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI SKIDTUBES.

Location/Lot Activity

Thursday, March 29, 2012 12:36:44 PM

Criteria : All Items All Locations Lot: 71502 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse / Location ID	Reason	Employee ID / Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date / Lot Code	Extended Cost
Account Value Change	D2896-1 / Support	Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	-20.0000	71502	-20.0000		($6,397.93)
		Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	20.0000	71502	20.0000		$6,397.93
								0.0000		**$0.00**
Inv Adjustment	D2896-1 / Support	Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		$319.90
		Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		$319.90
		Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/23/2012	1.0000	71502	1.0000		$319.90
		Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/27/2012	1.0000	71502	1.0000		$319.90
								4.0000		**$1,279.59**
Issue	D2896-1 / Support	Main Warehouse	73691	QUIR01		20.0000		20.0000		
		LG			10/19/2011	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	73690	QUIR01		19.0000		19.0000		
		LG			10/19/2011	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	75417	QUIR01		18.0000		18.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	75416	QUIR01		17.0000		17.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	74376	FAUT01		16.0000		16.0000		
		LG			11/21/2011	-1.0000	71502	-1.0000		($319.90)

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse LG	74377 -203	FAUT01	11/21/2011	15.0000 -1.0000	71502	15.0000 -1.0000		($319.90)
		Main Warehouse LG053	76351 -203	DESJ02	12/6/2011	35.0000 -1.0000	71502	14.0000 -1.0000		($319.90)
		Main Warehouse LG053	76350 -203	DESJ02	12/6/2011	34.0000 -1.0000	71502	13.0000 -1.0000		($319.90)
		Main Warehouse LG053	77108 -203	DESJ02	12/9/2011	33.0000 -1.0000	71502	12.0000 -1.0000		($319.90)
		Main Warehouse LG053	77273 -203	LAVO01	12/9/2011	32.0000 -1.0000	71502	11.0000 -1.0000		($319.90)
		Main Warehouse LG053	77109 -203	DESJ02	12/13/2011	31.0000 -1.0000	71502	10.0000 -1.0000		($319.90)
		Main Warehouse LG053	77433	QUIR01	12/19/2011	30.0000 -1.0000	71502	9.0000 -1.0000		($319.90)
		Main Warehouse LG053	77434	QUIR01	12/20/2011	29.0000 -1.0000	71502	8.0000 -1.0000		($319.90)
		Main Warehouse LG053	77748	FAUT01	1/6/2012	28.0000 -1.0000	71502	7.0000 -1.0000		($319.90)
		Main Warehouse LG053	77533	FAUT01	1/6/2012	27.0000 -1.0000	71502	6.0000 -1.0000		($319.90)
		Main Warehouse LG053	77534	FAUT01	1/6/2012	26.0000 -1.0000	71502	5.0000 -1.0000		($319.90)
		Main Warehouse LG053	78576	FAUT01	2/22/2012	25.0000 -1.0000	71502	4.0000 -1.0000		($319.90)
		Main Warehouse LG053	78574	FAUT01	2/22/2012	24.0000 -1.0000	71502	3.0000 -1.0000		($319.90)

Transaction Type	Item ID/ Item Name	Warehouse / Location ID	Reason	Employee ID / Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date / Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse	78575	FAUT01		23.0000		2.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	78573	GOLD01		22.0000		1.0000		
		LG053			2/24/2012	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	80135	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	80134	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	80585	GOLD01		22.0000		1.0000		
		LG053			3/23/2012	-1.0000	71502	-1.0000		($319.90)
		Main Warehouse	80584	GOLD01		22.0000		1.0000		
		LG053			3/27/2012	-1.0000	71502	-1.0000		($319.90)
								-24.0000		**($7,677.51)**
Loc Transfer	D2896-1 / Support	Main Warehouse		GOLD01		0.0000		0.0000		
		LG053			11/30/2011	14.0000	71502	14.0000		$4,478.55
		Main Warehouse		GOLD01		14.0000		14.0000		
		LG			11/30/2011	-14.0000	71502	-14.0000		($4,478.55)
								0.0000		**$0.00**
WIP Receipt	D2896-1 / Support	Main Warehouse	71502	GOLD01		0.0000		0.0000		
		LG			10/3/2011	20.0000	71502	20.0000		$6,397.93
								20.0000		**$6,397.93**